

Work Order ID 99802

April-12-13 7:39:38 AM

99802

Page 1

Item ID: D3245-9

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Gasket 8.35

Stop

NS2

Start Date: 4/11/13 Start Qty: 6.00

6

Cust Item ID:

Required Date: 4/11/13 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan:

P

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3245	D
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100	0.00
-----	------

100 FLOW WATER JET

Waterjet

Memo

0.00

6 0 JM 13-5-2

FLOW CNC Waterjet

I-Cut as per Dwg D3245

G-89

Dwg Rev: 0

Prog Rev: D

110	QC2- Inspect parts off machine FAI/FAIB	0.00
-----	---	------

110 QC

Memo

0.00

6 0 JM 13-5-2

Quality Control

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS														
			Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Use-as-is <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Machining <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Finishing <input type="checkbox"/>	Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/>	Quality <input type="checkbox"/>	Other <input type="checkbox"/>
Part No. _____			Work Order Update <input type="checkbox"/>																	
NCR No. _____																				
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description			Sign & Date	Verification		QC Inspector							
Doc/Data																				
Equip/Tooling																				
Operator																				
Material																				
Setup																				
Other																				
Process																				
Supplier																				
Training																				
Unapproved																				
FAULT CATEGORY																				
Landing Gear				General																
Bending	Bend	Grain	Ovalized								Pressure/Forced									
Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance								Temperature/Cure									
Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect								Weld									
Crushed/Crimped	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing								Wrong Stock Pulled									
Cuffs	Contamination	Maintenance	Part Moved																	
Heat Treat	Countersink	Mislabeled	Positioned Wrong																	
Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge																	
Ripples in Bend	Drill Holes	Offset	Other																	
Torque Waves in Extrusion	Drawing	Out of Calibration																		
Turning Sequence	Finish	Out of Sequence																		
Wave/Twist in Tube	Folio	Outside Dimensions																		

Work Order ID 99802

April-12-13 7:39:38 AM

99802

Page 2

Item ID: D3245-9

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Gasket 8.35

Stop

NS2

Start Date: 4/11/13

Start Qty: 6.00

6

Cust Item ID:

Required Date: 4/11/13

Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

Shp

120

QC

Quality Control

130

Identify as per dwg & Stock Location: ST 230

0.00

130

Packaging

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Quality Control

0.00

13/5/17 D

Q3-051

Box SP
13-5-7

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order:			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
Part No.:		NCR No.:									
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions						<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <hr/> <hr/> <hr/>	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <hr/> <hr/> <hr/>

Picklist Print

April-12-13 7:39:42 AM

Page 1

Work Order ID: 99802

99802
D3245-9

Parent Item: D3245-9

Parent Item Name: Gasket 8.35

Start Date: 4/11/13

Required Date: 4/11/13

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP B04.12.06 Made in-house KJ/JLM
IPP Rev:C ecn 1052/water jet 07-11-05 DD verified by:EC IPP Rev:D
12.11.07 PER DWG REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

G89		Purchased	No			100	sf	74.0000	0.0406	0.256421			
-----	--	-----------	----	--	--	-----	----	---------	--------	----------	--	--	--

G89

coated cloth

**

0.3

Jm13-5-2

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT052	74	
123993	4.5	
124498	69.5	124498

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

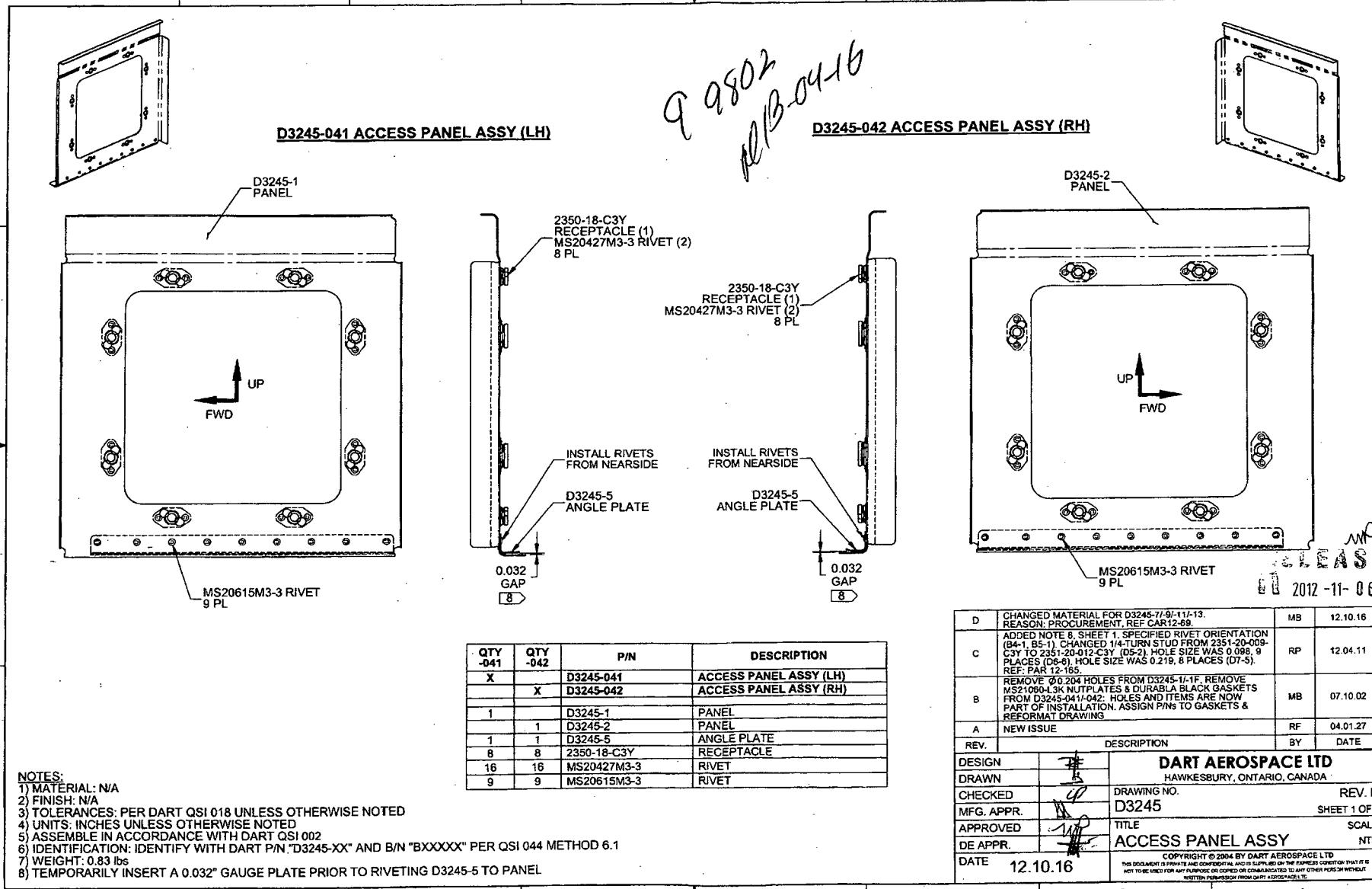
Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS							
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other						
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector				
Doc/Data													
Equip/Tooling													
Operator													
Material													
Setup													
Other													
Process													
Supplier													
Training													
Unapproved													
FAULT CATEGORY													
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions						<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <hr/> <hr/> <hr/>			
										<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <hr/> <hr/> <hr/>			
										<input type="checkbox"/> Other			

DART AEROSPACE LTD	Work Order:	
Description: Gasket	Part Number:	D3245-9
Inspection Dwg: D3245	Rev: <i>8/11</i> <i>13.0417</i>	Page 1 of 1

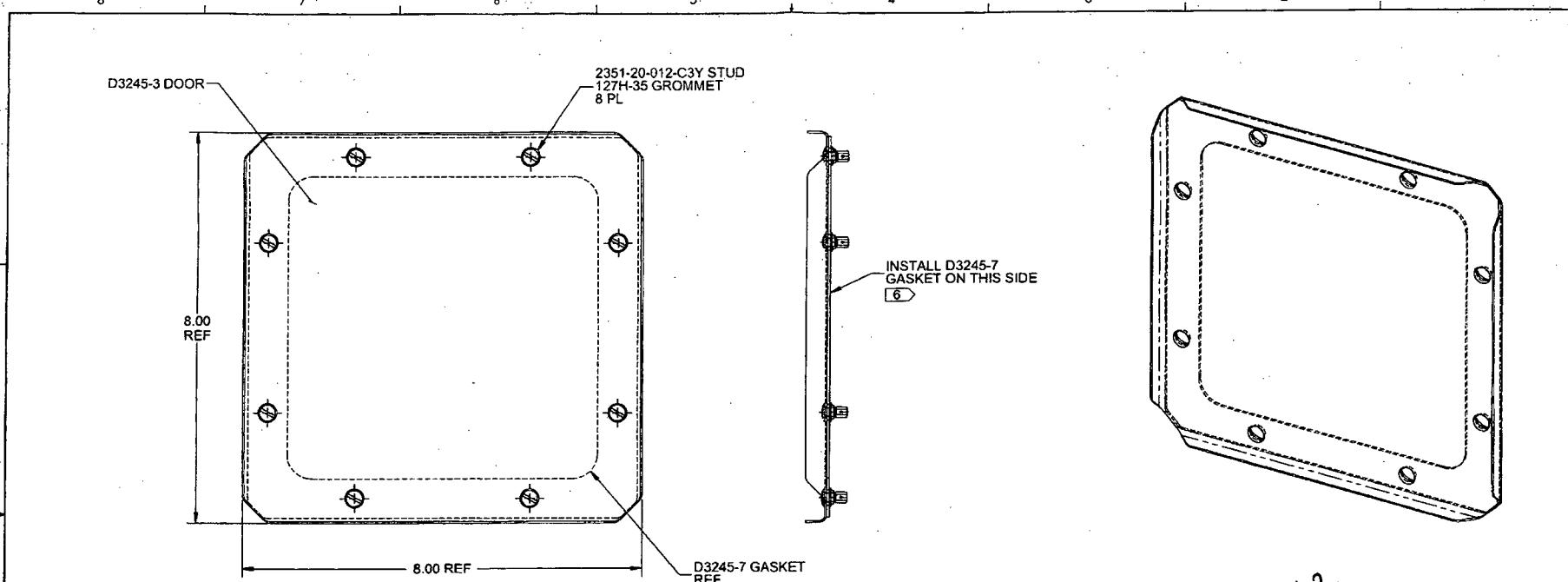
FIRST ARTICLE INSPECTION CHECKLIST

Measured by:	Jm	Audited by:	SMD	Preliminary Approval:	
Date:	13-5-2	Date:	BS2	Date:	

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	
B	12.06.19	Dimensions updated per Dwg Rev C	KJ	



D	CHANGED MATERIAL FOR D3245-7/9-11/13. REASON: PROCUREMENT REQUIREMENT.	MB	12.10.16
C	ADDED NOTE 8, SECTION 1, SPECIFIED RIVET ORIENTATION (B3-8) CHANGED 1/4" TURN STUD FROM 2351-20-009- C3Y TO 2351-20-012-C3Y. (D5-2) HOLE SIZE WAS 0.098, 9 PLACES (D6-6), HOLE SIZE WAS 0.219, 8 PLACES (D7-5). REF: PAR 12-165.	RP	12.04.11
B	REMOVE Ø.204 HOLES FROM D3245-1/-IF. REMOVE MS21060-L3K NUT PLATES & D3245-5 ANGLE PLATES FROM D3245-1/-IF. THESE HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN P/N'S TO GASKETS & REFORMAT DRAWING.	MB	07.10.02
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>TP</i>	DART AEROSPACE LTD	
DRAWN	<i>TP</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>CP</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>TP</i>	D3245	SHEET 1 OF 7
APPROVED	<i>TP</i>	TITLE	SCALE
DE APPR.	<i>TP</i>	ACCESS PANEL ASSY	NTS
DATE	12.10.16	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3245-043 DOOR ASSY

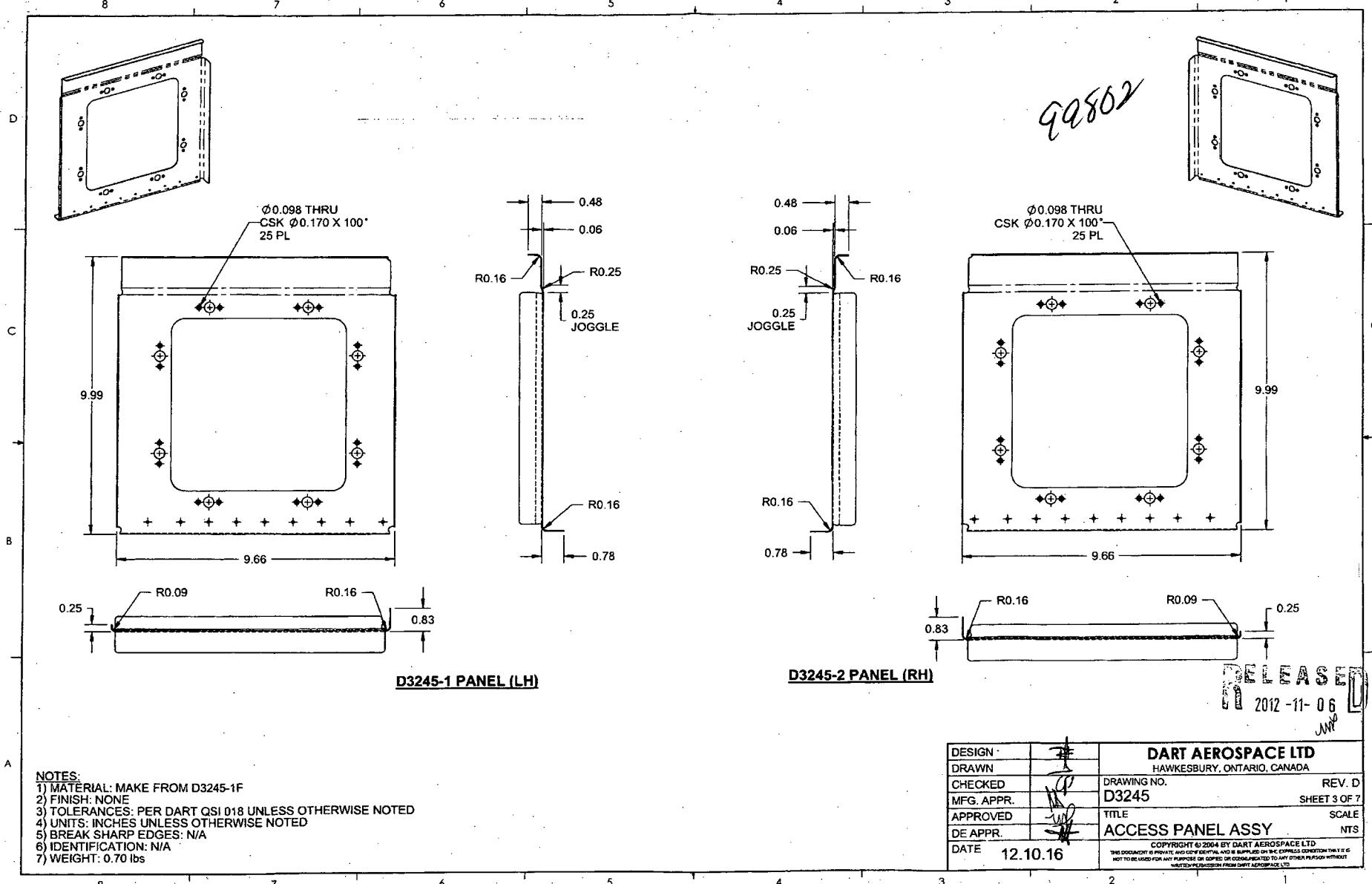
QTY -043	P/N	DESCRIPTION
X	D3245-043	ACCESS PANEL ASSY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	127H-35	GROMMET
8	2351-20-012-C3Y	STUD

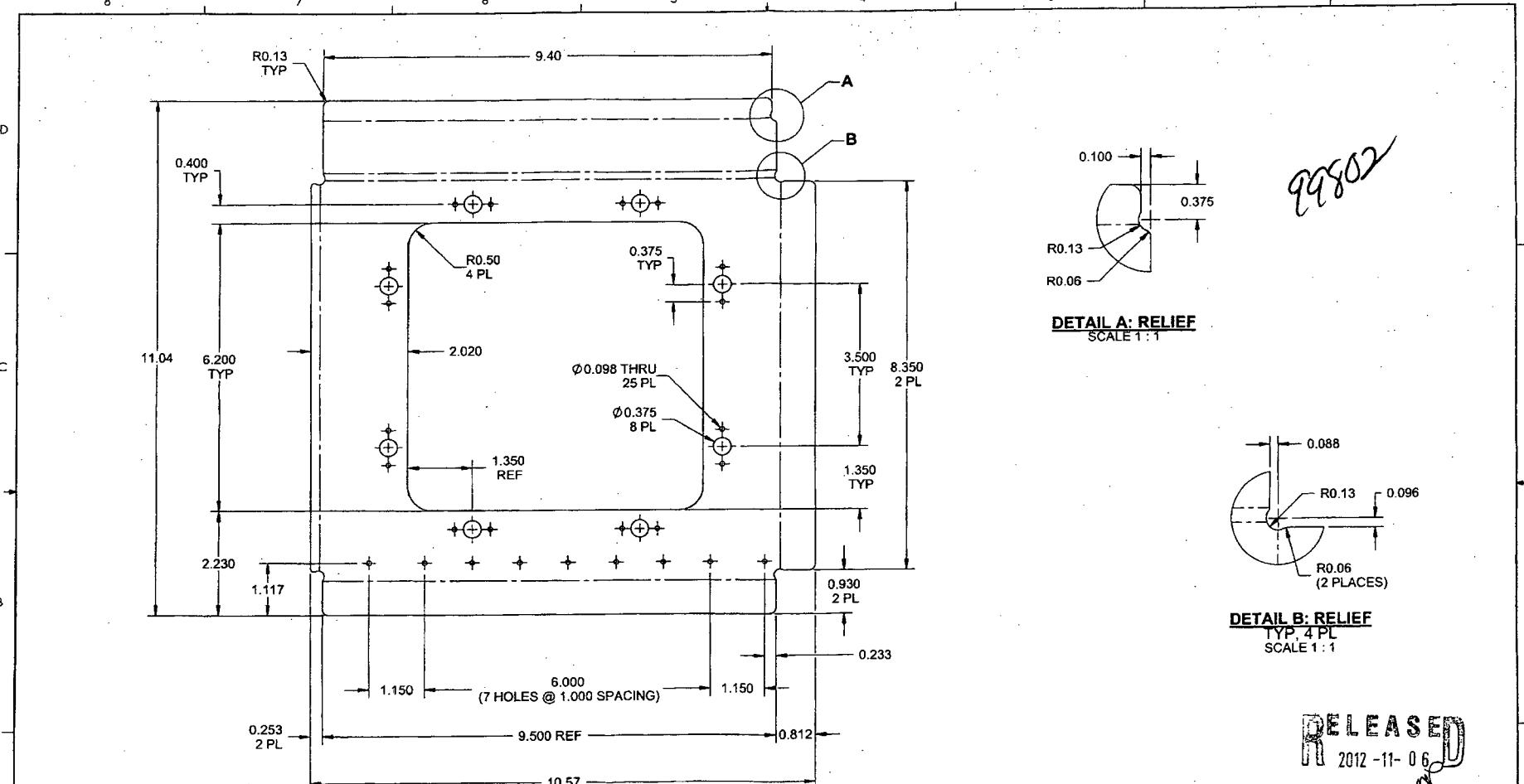
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" PER QSI 044 METHOD 6.1
- 9) WEIGHT: 0.74 lbs

RELEASED
2012-11-06
N/A

DESIGN	<u>DE</u>	DART AEROSPACE LTD	
DRAWN	<u>DE</u>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>DE</u>	DRAWING NO. REV. D	
MFG. APPR.	<u>DE</u>	D3245 SHEET 2 OF 7	
APPROVED	<u>DE</u>	TITLE SCALE	
DE APPR.	<u>DE</u>	ACCESS PANEL ASSY NTS	
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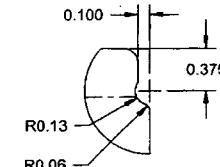




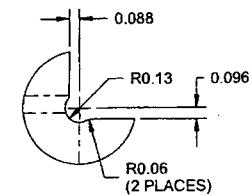
DESIGN	<u>RE</u>	DART AEROSPACE LTD
DRAWN	<u>RE</u>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<u>RE</u>	REV. D
MFG. APPR.	<u>RE</u>	DRAWING NO. D3245
APPROVED	<u>RE</u>	SHEET 4 OF 7
DE APPR.	<u>RE</u>	TITLE ACCESS PANEL ASSY
DATE	12.10.16	SCALE NTS

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99802

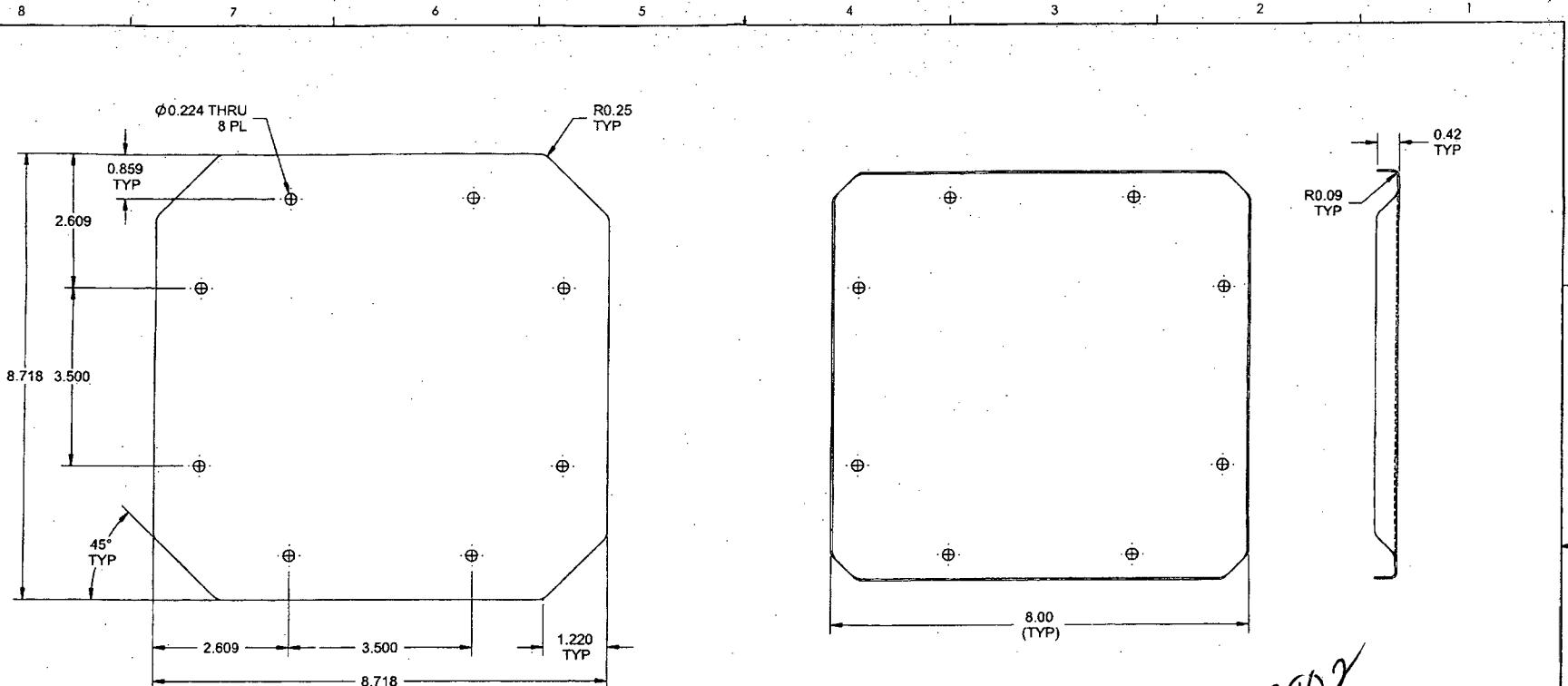


DETAIL A: RELIEF
SCALE 1:1



DETAIL B: RELIEF
TYP, 4 PL
SCALE 1:1

RELEASED
2012-11-06

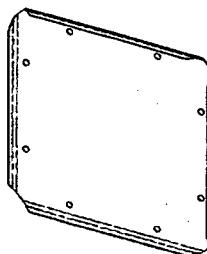


99801
D3245-3 DOOR
(MADE FROM D3245-3F)

RELEASED
2012-11-06
[Signature]

NOTES:

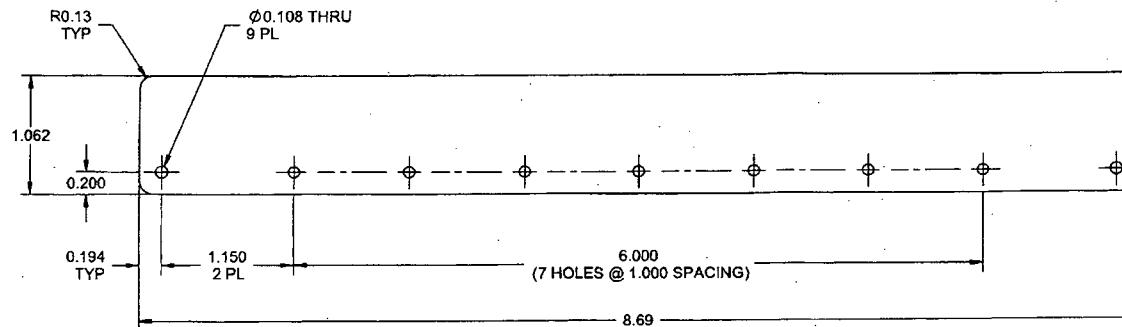
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- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.66 lbs



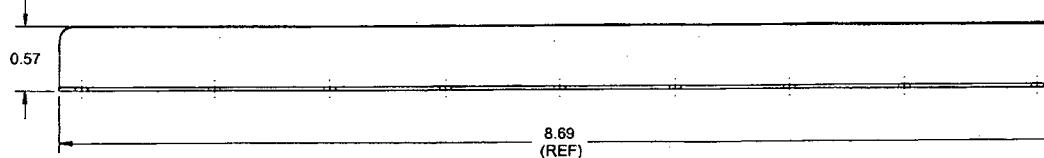
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DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO.
MFG. APPR.	<i>[Signature]</i>	REV. D
APPROVED	<i>[Signature]</i>	SHEET 5 OF 7
DE APPR.	<i>[Signature]</i>	TITLE
DATE	12.10.16	SCALE
		NTS

ACCESS PANEL ASSY

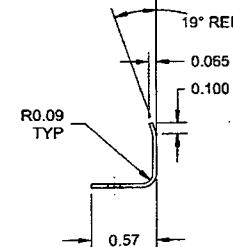
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D3245-5F FLAT PATTERN



D3245-5 ANGLE PLATE
(MAKE FROM D3245-5F)



RELEASE
R 2012-11-06
AM

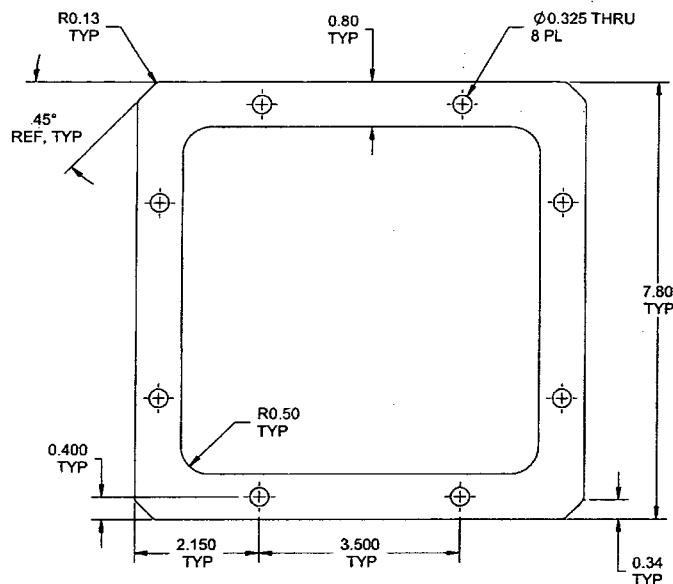
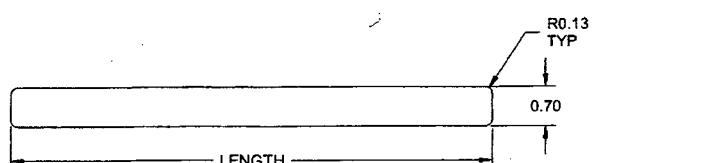
NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.032 THICK, ANNEALED, 2B FINISH, PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN	7E	DART AEROSPACE LTD
DRAWN	1A	HAWKESBURY, ONTARIO, CANADA
CHECKED	1D	DRAWING NO. D3245
MFG. APPR.		REV. D
APPROVED	1H	SHEET 6 OF 7
DE APPR.		TITLE
DATE	12.10.16	SCALE
		NTS
		ACCESS PANEL ASSY
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8 7 6 5 4 3 2 1

D

D3245-7 GASKETD3245-X GASKET

P/N	LENGTH
D3245-9	8.35
D3245-11	9.01
D3245-13	9.50

99808

B

A

NOTES:

- 1) MATERIAL: THERMO-CHEM P/N G-89, 0.060 THICK
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3245-7 = 0.04 lbs; D3245-9/11/13 = LESS THAN 0.01 lbs

8 7 6 5 4 3 2 1

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. D
MFG. APPR.		D3245 SHEET 7 OF 7
APPROVED		TITLE SCALE
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